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(54) **Molded wood composites having non-blistering profile with uniform paintability and nesting**

(57) A molded wood composite article man-made from wood fibers or wood particles on at least an upper, molded surface of the article, and a method of manufacturing the article to include a relatively uniform density, detailed design contours and textured aesthetics on one or more molded depression-interior inclined surfaces, while preventing embrittlement, softness and blistering of the article along the depression-interior inclined surfaces. These attributes are achieved by molding one or more depressions (20) into an initially planar layer of cellulosic material, wherein the molded depressions have one or more inclined walls (60) that have upper surfaces (62), along essentially an entire inclined span, that include detailed design contours, including adjacent curved and planar portions (64,66,) e.g. bead and cove. In one embodiment the angle of inclination of inclined upper wall surface (62) is 38° or less, e.g. about 25° to 38°. In another, the thickness of the inclined wall varies 20% or less in relation to the mean thickness which in turn is preferably about 2 to 15% thinner than the adjacent planar walls (46,72). The ends (68,70) of the inclined wall are preferably e.g. 1 to 12% less thick than the mean thickness of the wall between the ends.

FIG. 3A

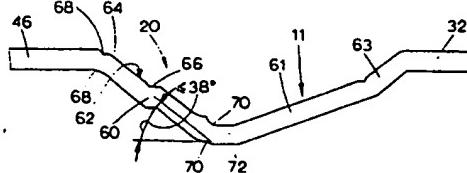


FIG. 3B



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## EUROPEAN SEARCH REPORT

Application Number

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DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int.Cl.6)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
X	US-A-2 682 083 (PATTON) 29 June 1954 * column 2, line 21 - line 52 * * column 3, line 25 - line 32 * * column 10, line 18 - line 47; claims; figures *	1-34	B27N3/00
A	---	35-38	
A	US-A-4 236 365 (WHEELER) 2 December 1980 ---		
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A	DE-A-38 01 486 (VD-WERKSTÄTTEN GMBH & CO KG) 3 August 1989 ---		
A	US-A-4 552 797 (MUNK ET AL.) 12 November 1985 ---		
A	US-A-3 212 948 (MCMAHON) 19 October 1965 ---		
A	US-A-4 277 428 (LUCK ET AL.) 7 July 1981 ---		
A	EP-A-0 049 299 (BOARD OF CONTROL OF MICHIGAN TECHNOLOGICAL UNIVERSITY) 14 April 1982 -----		TECHNICAL FIELDS SEARCHED (Int.Cl.6)
			B27N
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	30 January 1996	Soederberg, J	
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons A : member of the same patent family, corresponding document	
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